

Date: Thursday, 13/11/2008 1:09:26 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER ASSEMBLY		
Job Number	: 43430C			Part Number	: D3220042	
Estimate Number	: 10295			Drawing Number	: D3220 REV A1	
P.O. Number	:			Project Number	: N/A	
This Issue	: 13/11/2008		S.O. No. :	Drawing Revision	: A1	
Prsht Rev.	: NC			Material	:	
First Issue	: / /		Type :	MACHINED PARTS	Due Date	: 05/12/2008
Previous Run	: 40461C			Qty:	2	Um: Each
Written By	:					
Checked & Approved By	: <u>JUL 08.11.14</u>					
Comment	: Est Rev:A New Issue 05-11-06 JLM			Est: B	06.11.15	waterjet EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S050	2024-T3 .050 sheet
		Comment: Qty.: 0.7266 sf(s)/Unit Total : 1.4532 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.050" thick (M2024T3S.050) Identify for D3220-2 Batch: <u>18711</u> <u>HB 8-11-21</u>
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut D3220-1 as per Dwg D3220 Dwg Rev: <u>A1</u> <u>HB 8-11-21</u> Prog Rev: <u>A1</u>
		2-Deburr if necessary <u>HB 8-11-21</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		<u>HB 8-11-21</u>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		<u>806/11/21 (72)</u>
		Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1
		<u>1-Deburr</u> <u>M/A Done at step #2.2</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DOUBLER ASSEMBLY

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Job Number:



Seq. #: Machine Or Operation:

Description :

2-C'sink D3220-2 as per Dwg D3220

6.0 QC5

INSPECT WORK TO CURRENT STEP



EP08/11/08 (2)

Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(2X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M/ 08/11/08

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-78

(2)

9.0 MS20426AD34

RIVET



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 MS20426AD3-4 Rivet *M105978*

EP08/12/08

10.0 MS21059L4

Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS21059L4 Nutplate *M106322*

EP08/12/08

11.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3220-042 doubler as per Dwg D3220

EP08/12/08 (2)

12.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S08/12/08 (2) (042)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 13/11/2008 1:09:26 PM
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Part Number: D3220042

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST234

AS 08/12/08

14.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/08

Job Completion



4 08-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43430
Description: Doubler	Part Number:	D3220-2
Inspection Dwg: D3220	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	BB	Audited by:	S	Prototype Approval:	N/A
Date:	9-11-21	Date:	08/16/21	Date:	N/A

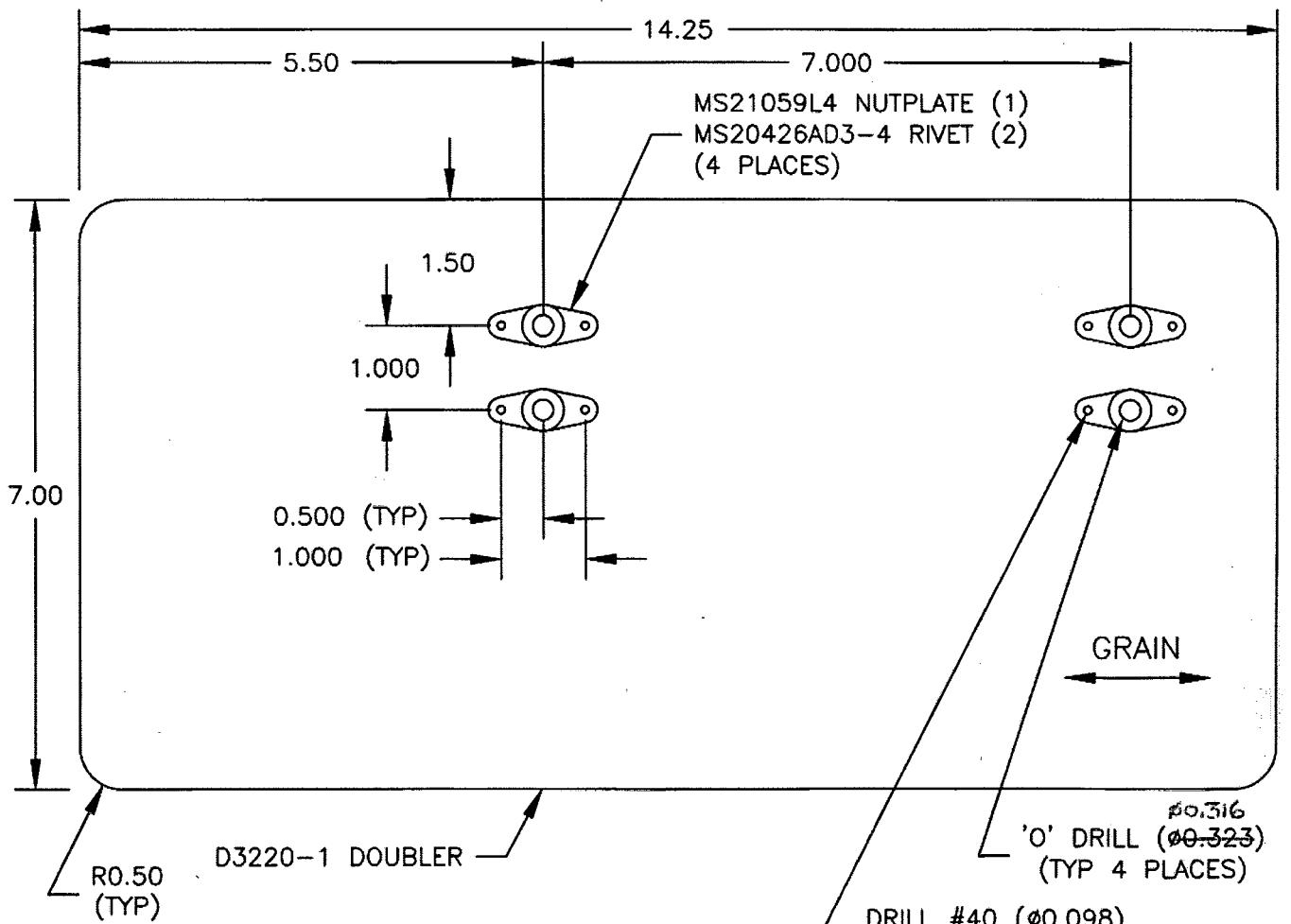
Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	P/O D3220-042	KJ/JLM <i>✓</i> <i>E</i>



DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED 	APPROVED 	DRAWING NO. D3220	REV. A	SHEET 1 OF 2
DATE 03.10.16		TITLE DOUBLER	SCALE 1:2	
A	03.10.16	NEW ISSUE		
A1	 03.11.13	CORRECTED DIM		

A rectangular stamp with a double-line border. The word "RELEASED" is printed in large, bold, black capital letters across the top. In the center, there is a rectangular box containing the date "03.11.14". Below the date is a horizontal line for a signature, which is partially visible on the right side of the stamp.

03.11.14



D3220-041 (SHOWN) / -042 (OPPOSITE) DOUBLER ASSEMBLY (D3220-1 DOUBLER)

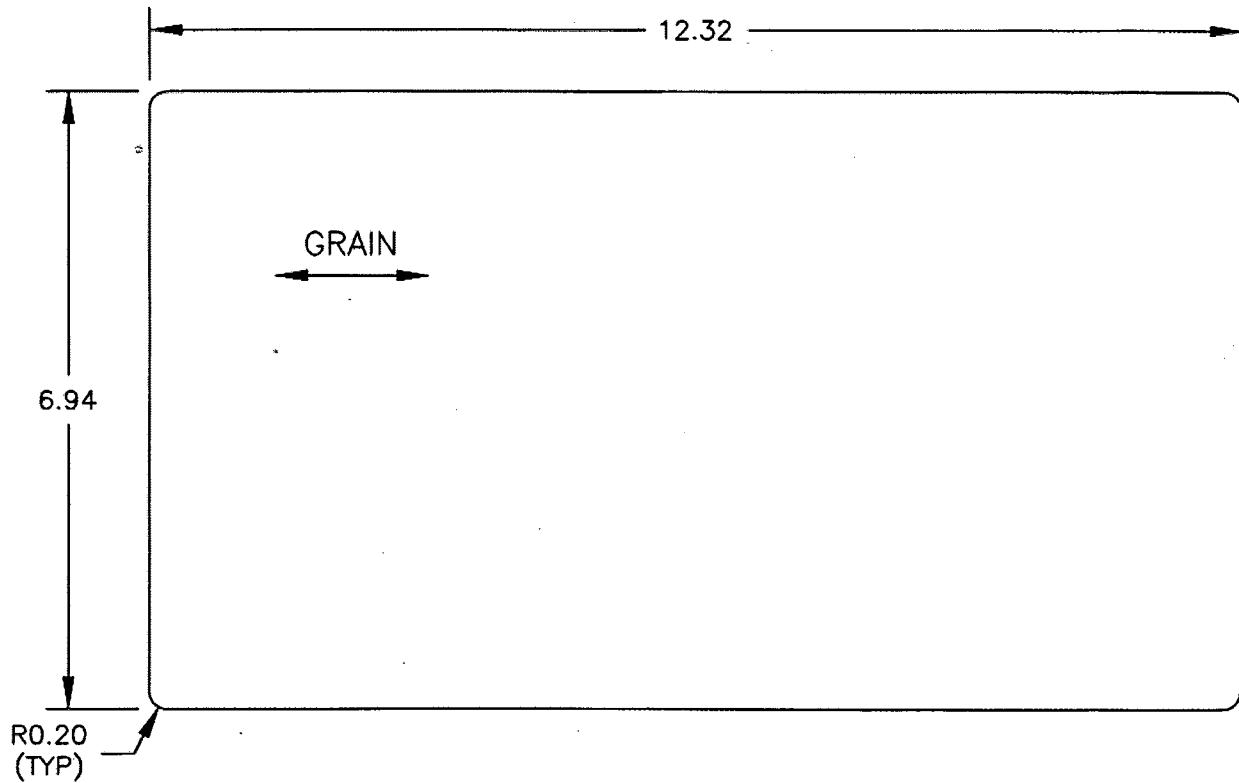
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
(REF. DART SPEC. M2024T3S.090)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

98)
00° OTHER SIDE
SHOP COPY
ER) RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK COPY
NO. 43430C



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3220
DATE	TITLE	REV. A SHEET 2 OF 2 SCALE 1:2
03.10.16	DOUBLER	

RELEASED
03.11.14



D3220-3 DOUBLER

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
(REF DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 213730C